

Work Order ID 54729-1

December 17, 2009 11:34:31 AM



Page 1

Item ID: D3929-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 17/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 04-12-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3929

Rev A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

WB 10-1-4

9

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

WB 10-1-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 6.00



Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8/10/01/04

⑨

Quality Control

130

Pick Kit

0.00



Packaging

Memo

0.00

PD 10.01.05

Packaging

140

0.00



Large Fab

Memo

0.00


Weld bushings D3907-1 as per dwg D3929

316L rod batch: H109213

Pho →

PD 10.01.05 ⑥



W/O: 54729		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	140	w/o was split due to extra made. 6 parts on this w/o + 3 parts of split of <del>split</del> - 2 w/o					

Part No: D3929-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Work Order ID 54729

December 17, 2009 11:34:32 AM



Page 3

Item ID: D3929-041-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 17/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10/01/05

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8 10/01/06

46

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

Break & cell

SM 10/01/06

6x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54729**

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Item ID: D3929-041

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Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 17/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/07

MF

10-01-06



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

December 17, 2009 11:34:36 AM

Page 1

Work Order ID: 54729

Parent Item: D3929-041

Parent Item Name: Gusset Assembly

Comments:

Start Date: 17/12/2009

Required Date: 23/12/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

107.0791

2.8421

4.3



304/316 0.125 Sheet

HB 10-1-4

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

107.0791

112663

107.0791

112663

D3907-1

Manufactured

No

130

Each

57.0000

12.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

53673

17

PD 10.01.05

Main Warehouse

WA

40

54042

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





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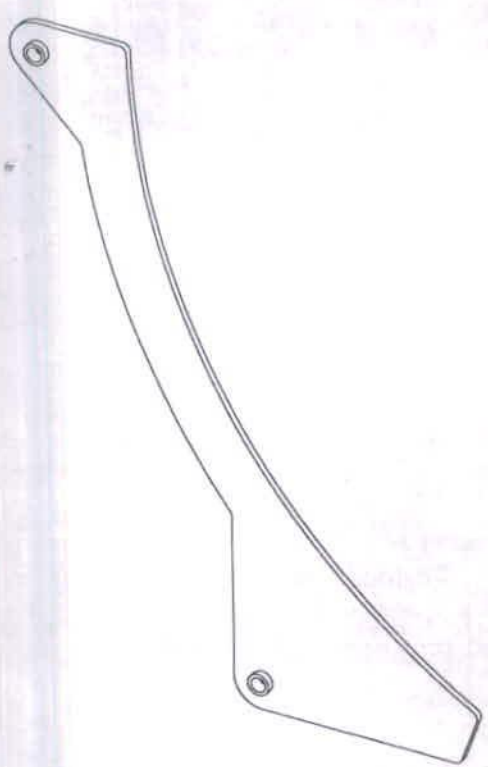
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

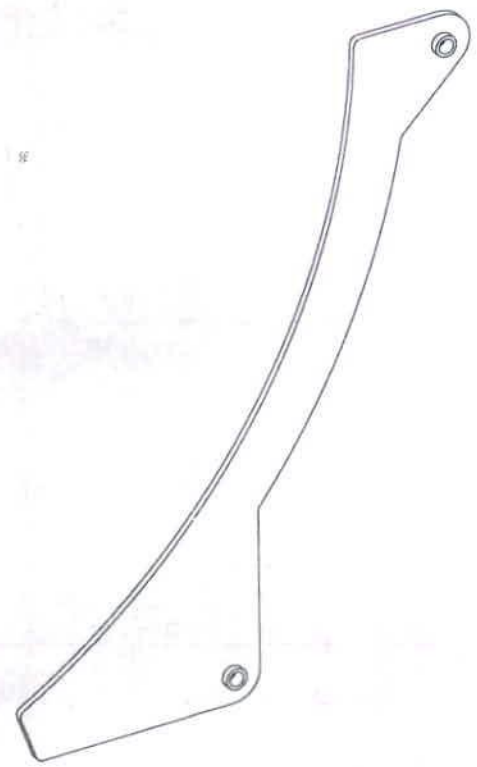
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**NOTE:** Date & initial all entries





D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54729  
*PL 0912-17*

RELEASED  
*27/04/12 MD*

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT: 0.73 lbs EACH  
8) WELDING: PER DART QSI 004

A	NEW ISSUE		MB	09.04.03
REV		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO		REV. A
MFG APPR.		D3929		SHEET 1 OF 3
APPROVED		TITLE		SCALE
DE APPR.		GUSSET ASSEMBLY		NTS
DATE	09.04.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

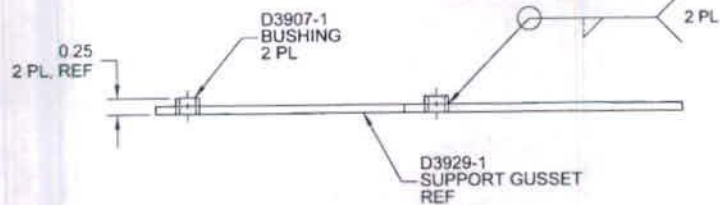
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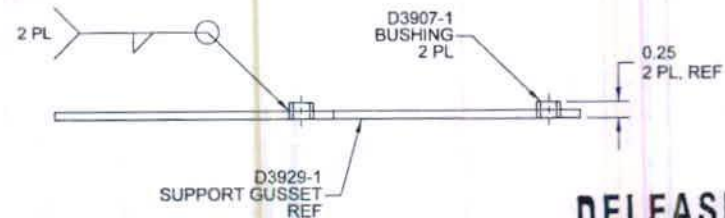
**NOTE:** Date & initial all entries

D3929-1  
SUPPORT GUSSET  
2 PL

D3929-1  
SUPPORT GUSSET  
2 PL



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

**RELEASED**  
09/04/27/10

w/o 54729

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
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W/O:		WORK ORDER CHANGES					
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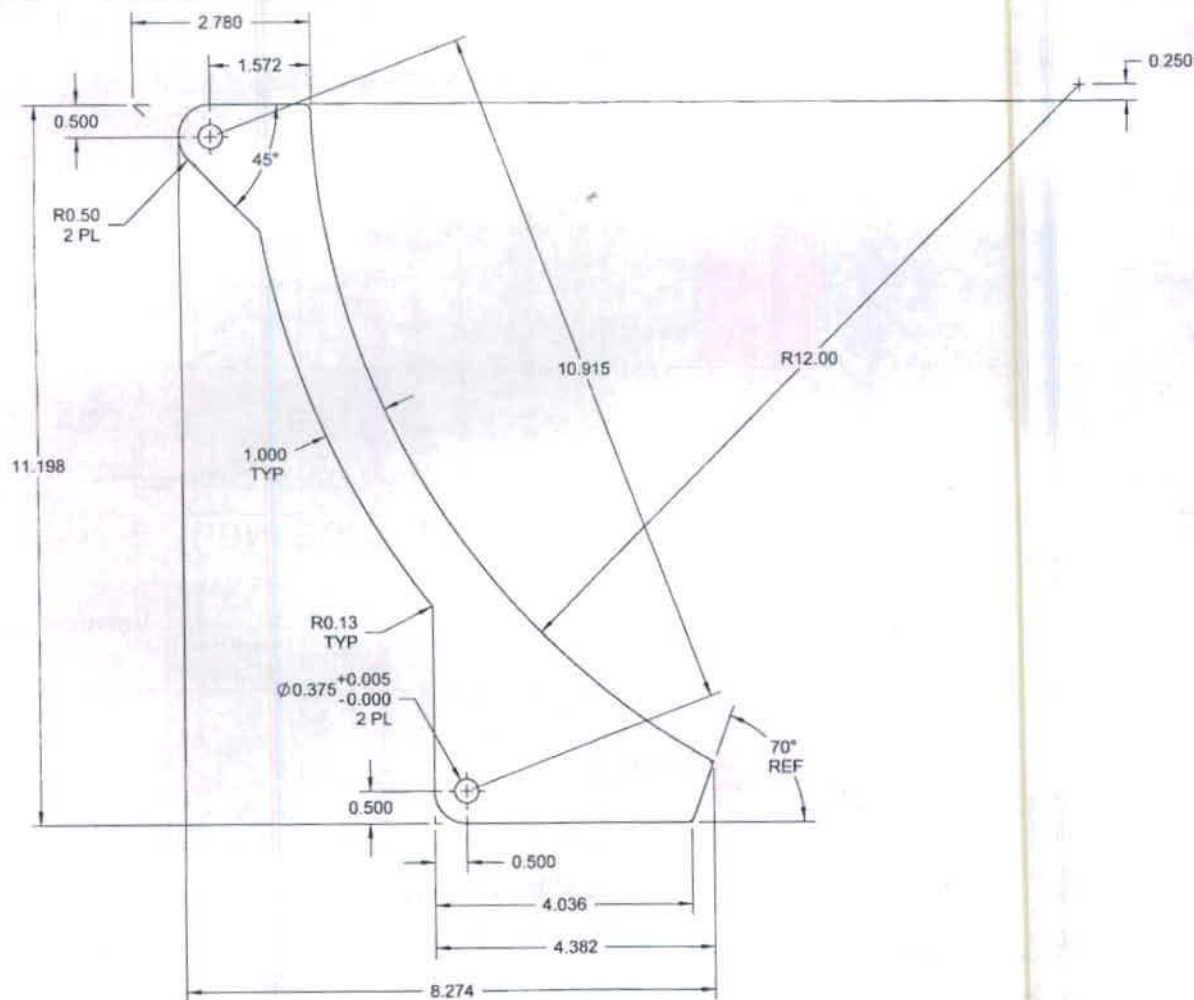
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3929-1 SUPPORT GUSSET**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
11 GAUGE (0.125 THICK)  
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

DESIGN		<b>RELEASED</b> 09/04/22	
DRAWN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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